

Work Order ID 61234

Page 1

August 11, 2010 11:11:21 AM

Item ID: D4149-5

Accept



Setup Start



Revision ID:

Item Name: Eyebolt Stud

Stop



Start Date: 8/11/10 Start Qty: 10.00



Cust Item ID:

Required Date: 8/25/10 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan: C2

Date: 10/8/11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
| D4149 | B |

100

0.00



Doosan

Memo

0.00

Doosan Lathe

turn as per dwg and folio FA950

DWG REV: B

FOLIO REV: AA

SL 10/08/12

(10)

Ø

110



QC

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

SL 10/08/12

10

Ø

Quality Control

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Picklist Print

Page 1

August 11, 2010 11:11:20 AM

Work Order ID: 61234



Parent Item: D4149-5



Parent Item Name: Eyebolt Stud

Start Date: 8/11/10

Required Date: 8/25/10

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV:A NEW ISSUE 10-07-22 JLM VERIFIED BY:DD

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M303R1.000 | | Purchased | No | | | f | | 4.0560 | 0.25 | 2.631579 | | | |

.303 Round Bar 1.00

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| MAT028 | 4.056 | |
| 113325 | 4.056 | |

304 R1.000
This Batch L
On 1/1/08/13 not removed 109541 2.64 JL 10/08/12

Jan 10, 08/13

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

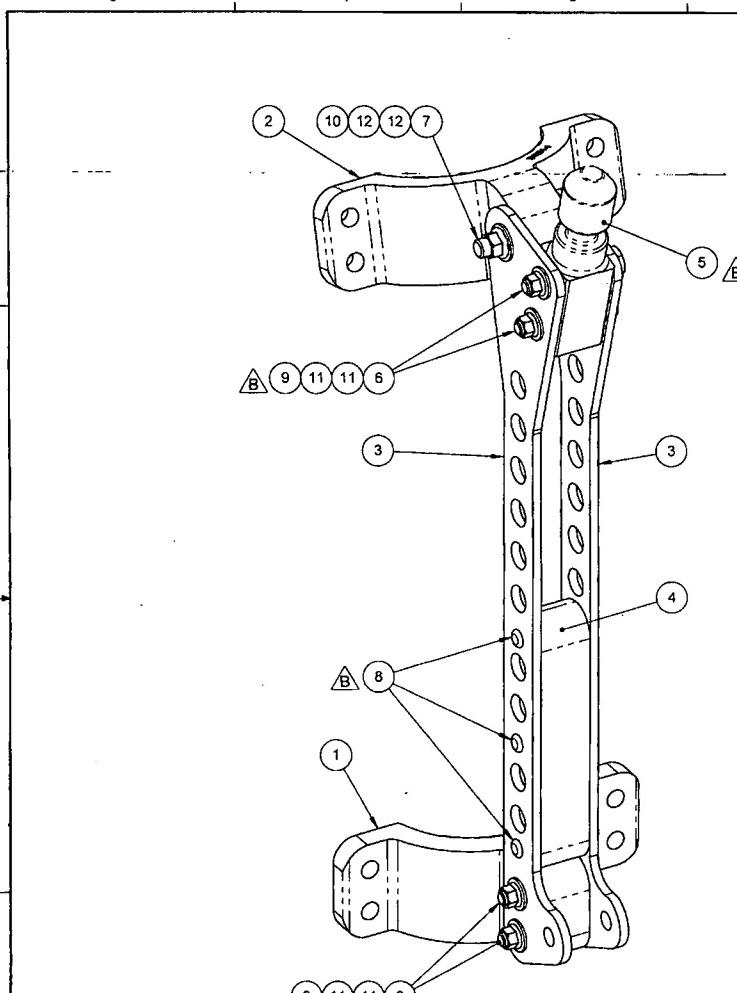
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| | | |
|-------------------------------|--------------|-------------|
| DART AEROSPACE LTD | Work Order: | 61234 |
| Description: eyebolt stud | Part Number: | 154149-5 |
| Inspection Dwg: 154149 Rev: B | | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

| | | | | | |
|--------------|-----------------|-------------|-----------------|-----------------------|--|
| Measured by: | <u>S.L</u> | Audited by: | <u>M.A</u> | Preliminary Approval: | |
| Date: | <u>10/08/12</u> | Date: | <u>10/08/14</u> | Date: | |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|----------------------------|------------|----------|
| E | 10.04.14 | Added preliminary approval | KJ | |



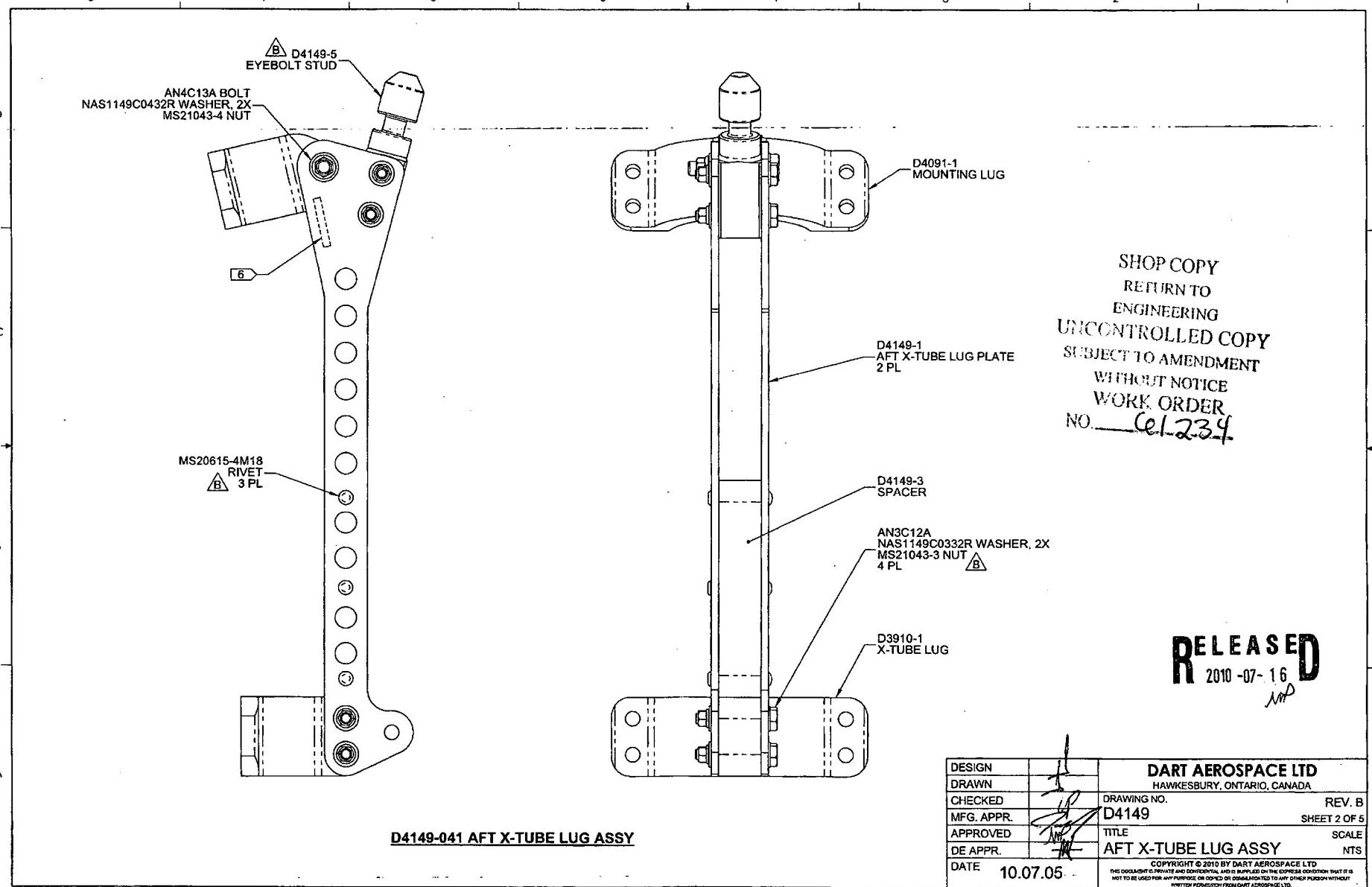
D4149-041 AFT X-TUBE LUG ASSY

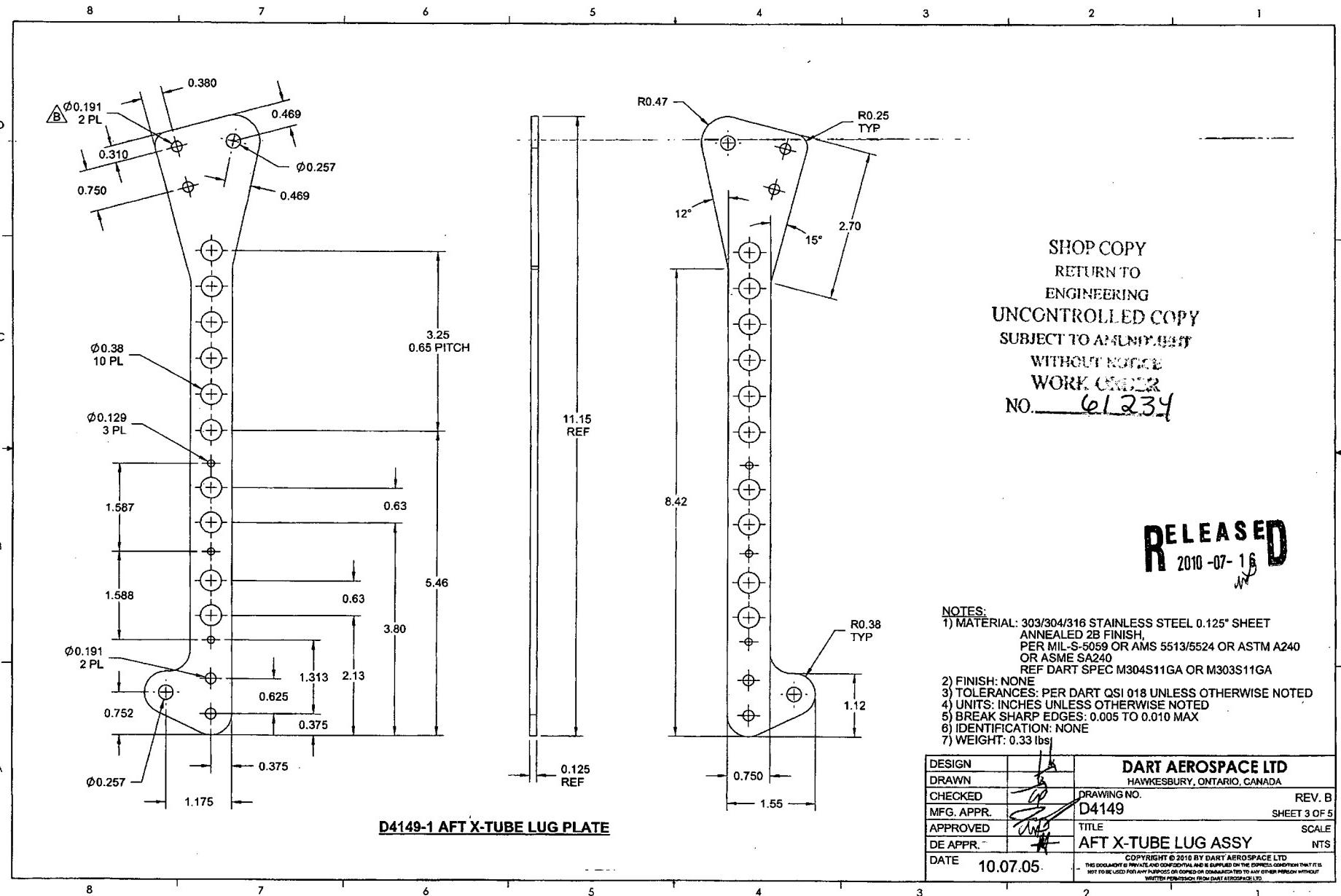
NOTES:
 1) MATERIAL: N/A
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: N/A
 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4149-041" USING FINE POINT PERMANENT INK MARKER
 7) WEIGHT: 2.17 lbs.

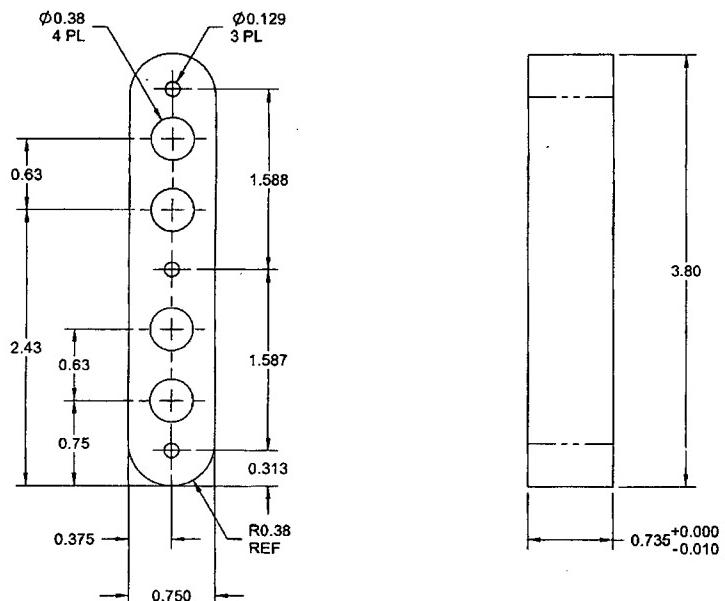
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 NO. 61239
 CL108111

| ITEM | QTY -041 | P/N | DESCRIPTION |
|------|-------------|---------------|---------------------------------|
| | | | X D4149-041 AFT X-TUBE LUG ASSY |
| 1 | 1 | D3910-1 | X-TUBE LUG |
| 2 | 1 | D4091-1 | MOUNTING LUG |
| 3 | 2 | D4149-1 | AFT X-TUBE LUG PLATE |
| 4 | 1 | D4149-3 | SPACER |
| 5 | 1 | D4149-5 | EYEBOLT STUD |
| 6 | 4 | AN3C12A | |
| 7 | 1 | AN4C13A | BOLT |
| 8 | 3 | MS20615-4M18 | RIVET |
| 9 | 4 | MS21043-3 | NUT |
| 10 | 1 | MS21043-4 | NUT |
| 11 | 8 | NAS1149C0332R | WASHER |
| 12 | 2 | NAS1149C0432R | WASHER |

| | | | |
|------------|--|--|--------------|
| B | MS20615-4M18 WAS MS20615-4M20 (ZN D3-1 & B7-2), D4149-5 WAS D3909-5 (ZN D3-1 & D7-2); REPLACES BOTH MS20615-4M18 AND D4149-5 (ZN D3-1 & D7-2). EACH AN3C12A, MS21043-3 AND QTY(4) NAS1149C0332R WASHER (ZN D3-1, C7-1, B7-2 & B3-2); Ø 0.191 2 PL REPLICATES Ø 0.129 3 PL (ZN D8-3). REASON: SEE TR-D350-607-2 REV. B. | MB | 10.07.05 |
| A | NEW ISSUE | MB | 10.06.18 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | <i>A</i> | DART AEROSPACE LTD | |
| DRAWN | <i>b</i> | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | <i>gj</i> | DRAWING NO. | REV. B |
| MFG. APPR. | <i>sl</i> | D4149 | SHEET 1 OF 5 |
| APPROVED | <i>mp</i> | TITLE | SCALE |
| DE APPR. | <i>mp</i> | AFT X-TUBE LUG ASSY | NTS |
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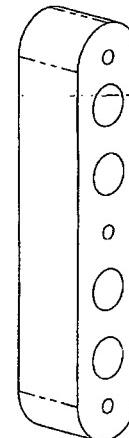






D4149-3 SPACER

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NO. 61234



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|------------|-----------|---|--------------|--|
| DESIGN | <u>15</u> | DART AEROSPACE LTD | | |
| DRAWN | <u>13</u> | HAWKSBURY, ONTARIO, CANADA | | |
| CHECKED | <u>SD</u> | DRAWING NO. | REV. B | |
| MFG. APPR. | <u>SD</u> | D4149 | SHEET 4 OF 5 | |
| APPROVED | <u>JW</u> | TITLE | SCALE | |
| DE APPR. | <u> </u> | AFT X-TUBE LUG ASSY | NTS | |
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NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A276 OR A582
REF DART SPEC MS304B OR MS303B
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.47 lbs

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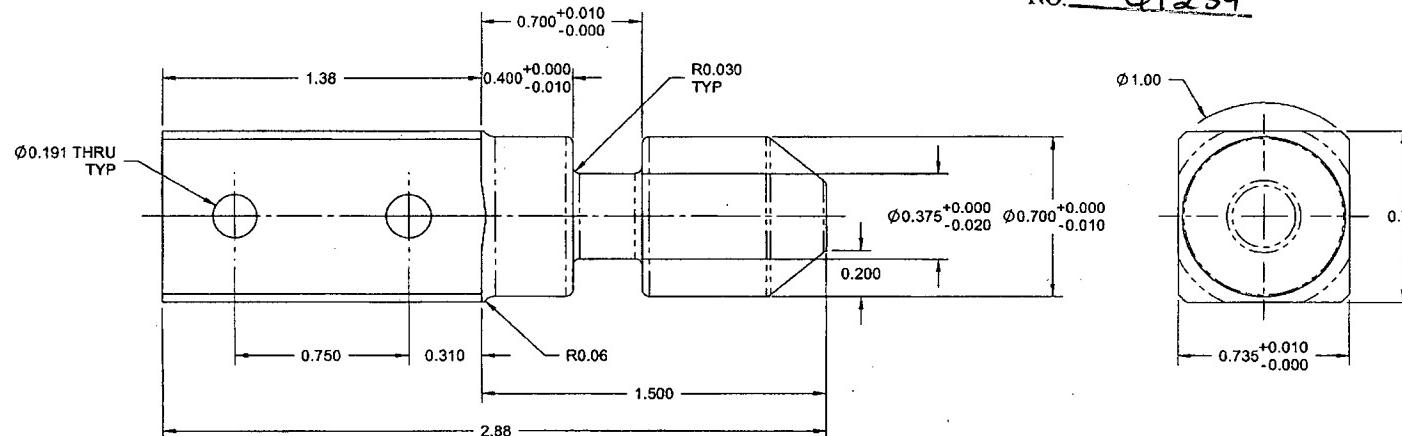
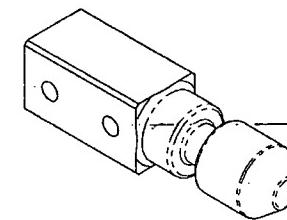
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WORK ORDER

NO. ce1234



△ D4149-5 EYEBOLT STUD

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2010-07-16

A NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A276 OR A582
REF DART SPEC MS304B OR MS303B
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4149-5" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.33 lbs

| | | |
|------------|--------------------|-----------------------------|
| DESIGN | <i>[Signature]</i> | DART AEROSPACE LTD |
| DRAWN | <i>[Signature]</i> | HAWKESBURY, ONTARIO, CANADA |
| CHECKED | <i>[Signature]</i> | DRAWING NO. |
| MFG. APPR. | <i>[Signature]</i> | REV. B |
| APPROVED | <i>[Signature]</i> | D4149 SHEET 5 OF 5 |
| DE APPR. | <i>[Signature]</i> | TITLE |
| DATE | 10.07.05 | SCALE |
| | | NTS |

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